

Work Order ID 62829

Friday, October 08, 2010 12:48:49 PM

Page 1

Item ID: D3686-041

Accept

Setup Start

Revision ID:

Stop

Item Name: MONOPOD ASSEMBLY

Start Date: 10/8/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3686

Rev D

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

110

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Use anti-seize compound Tectly 502c Class 1,Mil-PRF-16173E or equivalent
on thread and assemble as per dwg D3686

2-Assemble D3693-1 & D3691-1 & D3693-3 & D3688-7 Using Sikaflex -241/-
291 between mating surfaces as per Dwg D3686

***Ensure holes for AN3C Bolts are free of sealant.
Torque Fastners as per Dwg D3686

EP 10/10/14 (2)

EP 10/10/14 (2)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

2 10/10/14

130

Identify as per dwg & Stock Location: 177

0.00



Packaging

Memo

0.00

Packaging

10/10/18 2

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/18
CMF
10-10-18

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Picklist Print

Friday, October 08, 2010 12:48:53 PM

Page 1

Work Order ID: 62829

Parent Item: D3686-041

Parent Item Name: MONOPOD ASSEMBLY



Start Date: 10/8/2010

Required Date: 10/15/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A new issue 08-02-12 DD verified by:JLM
 IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC IPP
 REV:C AS PER REV D 10-03-16 JLM VERIFIED BY:EC
 IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3688-7 STUD		Manufactured	No			110	Each	7.0000	1	2			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>ST081</div> <div>7</div> <div></div> </div>													
<div> <div>44686</div> <div>1</div> <div></div> </div>													
<div> <div>50931</div> <div>6</div> <div></div> </div>													
D3689-1 SLEEVE		Manufactured	No			110	Each	6.0000	1	2			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>ST76</div> <div>6</div> <div></div> </div>													
<div> <div>62188</div> <div>6</div> <div></div> </div>													
D3691-1 STUD		Manufactured	No			110	Each	25.0000	1	2			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>ST077</div> <div>16</div> <div></div> </div>													
<div> <div>61370</div> <div>16</div> <div></div> </div>													
<div> <div>ST082</div> <div>9</div> <div></div> </div>													
<div> <div>58631</div> <div>9</div> <div></div> </div>													

EP 10/10/14

EP 10/10/14

EP 10/10/14

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Friday, October 08, 2010 12:48:53 PM

Page 2

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Parent Item: D3686-041






Parent Item Name: MONOPOD ASSEMBLY

Start Date: 10/8/2010

Required Date: 10/15/2010

Start Qty: 2.00

Required Qty: 2.00

D3692-1	Manufactured	No	110	Each	305.0000	4	8
							
SPACER							
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
			ST082	305			
			51467	305			
D3692-3	Manufactured	No	110	Each	41.0000	4	8
							
SPACER							
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
			ST082	41			
			44690	41			
D3693-1	Manufactured	No	110	Each	34.0000	1	2
							
Rod End Bearing							
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
			ST082	34			
			50734	34			
D3693-3	Manufactured	No	110	Each	5.0000	1	2
							
Rod End Bearing							
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
			ST082	5			
			50723	5			
AN3C10A	Purchased	No	110	Each	34.0000	2	4
							
Bolt							
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
			ST351	34			
			105940	14			
			112489	20			

Friday, October 08, 2010 12:48:53 PM

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Page 2

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Page 3

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Parent Item Name: MONOPOD ASSEMBLY

Start Date: 10/8/2010

Required Date: 10/15/2010

Start Qty: 2.00

Required Qty: 2.00

AN3C12A Purchased No 110 Each 50.0000 2 4
Bolts

Location	Loc Qty	Loc Code
ST351	50	
112314	8	
114761	11	
115392	11	
115594	20	

MS21043-3 Purchased No 110 Each 2,579.000 4 8
Nut

Location	Loc Qty	Loc Code
FG	76	
103691	76	
ST301	2503	
111383	38	
112314	2465	

NAS509L12C Purchased No 110 Each 45.0000 1 2
Nuts

Location	Loc Qty	Loc Code
ST280	45	
112314	35	
112828	10	

NAS509-12C Purchased No 110 Each 40.0000 1 2
Nuts

Location	Loc Qty	Loc Code
ST280	40	
112453	40	

Friday, October 08, 2010 12:48:53 PM

Shop Packet Print

Page 3

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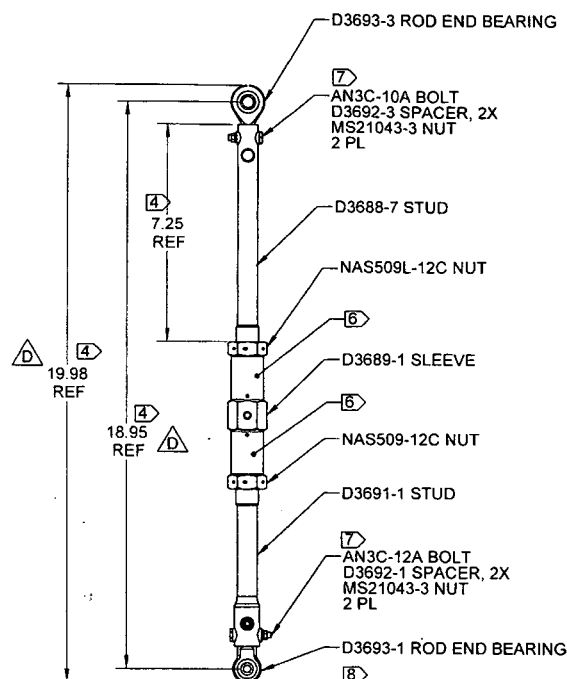
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ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D3686-041	MONOPOD ASSEMBLY
2	1	D3688-7	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	4	D3692-3	SPACER
7	1	D3693-1	ROD END BEARING
8	1	D3693-3	ROD END BEARING
9	2	AN3C-10A	BOLT
10	2	AN3C-12A	BOLT
11	4	MS21043-3	NUT
12	1	NAS509L-12C	NUT
13	1	NAS509-12C	NUT



D3686-041 MONOPOD ASSEMBLY

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3686-041 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSIONS SHOWN ARE WHEN D3688-7 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.0 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 & D3693-3 WITH D3688-7 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

UNCONTROLLED COPY
SUBJECT TO CHANGE

NO. 42827
B810-10-8

RELEASED
R 2010-03-15

D	19.98 WAS 20.10 (ZN C6-1); 18.95 WAS 19.07 (ZN C5-1)	RF	10.03.03
C	ROD END BEARINGS NOW ASSEMBLED USING SEALANT (ZN A8-1, B4-1)	RF	08.12.15
B	REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.05.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D3686	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MONOPOD ASSEMBLY	NTS
DATE	10.03.03	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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